

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015611**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|---------|---------------------|-----|----------------------------------|-----|----|-----|
| CWI Name: | N/A | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | OBG | | | | |

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 9BE-9CE

ABF Report No: UT-9E-063

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and bottom panel (cross beam side) of OBG segment 9BE and 9CE. The weld designations are as follows.

SEG052A-021 (OBG 9BE- S.P to B.P, CB side @ 9CE)

SEG054A-013 (OBG 9CE- S.P to B.P, CB side @ 9BE)

CROSS BEAM # 13

ABF Request No: 07142010-1

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and deck panel (East side) of cross beam # 13. Inspection was carried out on repair areas. The weld designations are as follows.

CB202A-013-002 (CB# 13- S.P to D.P, East side)

CROSS BEAM # 14

ABF Request No: 07142010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and deck panel (East side) of cross beam # 14. Inspection was carried out on repair areas. The weld designations are as follows.

CB202A-014-002 (CB# 14- S.P to D.P, East side)

CROSS BEAM # 13

ABF Request No: 07142010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and deck panel (West side) of cross beam # 13. Inspection was carried out on repair areas. The weld designations are as follows.

CB202A-013-014 (CB# 13- S.P to D.P, West side)

MAGNETIC PARTICLE INSPECTION

CROSS BEAM # 14

ABF Request No: 07142010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and side panel (East side) of cross beam # 14. Inspection was carried out on repair areas. Weld identification number were.

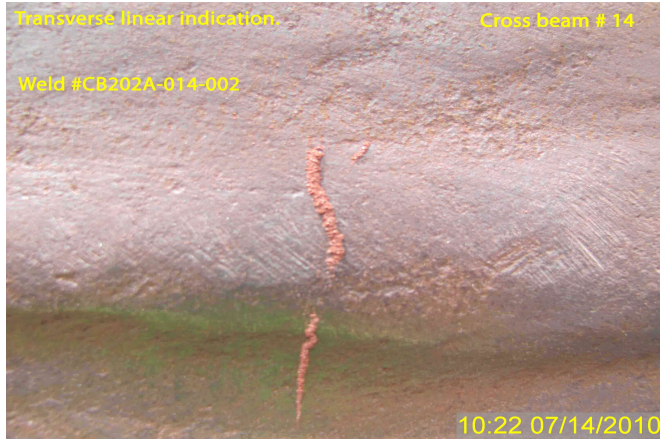
CB202A-014-002 (CB# 14- S.P to D.P, East side)

During the magnetic particle inspection on the repair areas of weld CB202A-014-002 ABF QA Inspector found a transverse linear indication. Y location of indication measured approximately 4660mm. The length of indication was measured approximately 25mm. see attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Peterson,Art | QA Reviewer |
